

pin, and removing the cylindrical article from the core by pushing a bottom portion of the gate cylindrical molded body. --.

-- 13. The molding method set forth in claim 4, wherein the insert is fitted, closely attached and held in a cylindrical shape along the inner peripheral surface of the outer mold unit in the molding cavity inside the injection molding mold by partially fitting the insert in a cylindrical shape into the outer mold unit of the mold in a state that the core of the injection molding mold is pulled out from the outer mold unit and the molding cavity is opened, forwardly moving the core into the outer mold unit, and applying a contact frictional force between the core and the insert. --.

-- 14. The molding method set forth in claim 5, wherein the insert is fitted, closely attached and held in a cylindrical shape along the inner peripheral surface of the outer mold unit in the molding cavity inside the injection molding mold by partially fitting the insert in a cylindrical shape into the outer mold unit of the mold in a state that the core of the injection molding mold is pulled out from the outer mold unit and the molding cavity is opened, forwardly moving the core into the outer mold unit, and applying a contact frictional force between the core and the insert. --.

-- 15. The molding apparatus set forth in claim 8, wherein radial molten resin runner grooves are formed at a joint face between one end of the core and the end portion-molding mold unit, and one end opening of the gate hole is to communicate with end portions of the running grooves. --.

-- 16. The apparatus set forth in claim 8, wherein the outer mold comprising a stopper mold movable axially and adapted to form the other end of the cylindrical molded body, and the releasing tool is said stopper mold. --.

-- 17. The apparatus set forth in claim 9, wherein the outer mold comprising a stopper mold movable axially and adapted to form the other end of the cylindrical molded body, and the releasing tool is said stopper mold. --.

-- 18. The apparatus set forth in claim 8, wherein the releasing tool further comprises a knock-out pin provided movably forwardly and rearwardly in a central portion of the core, and connection between the cured resin inside the injection gate opening and the cylindrical molded body is cut by raising the knock-out pin. --.

-- 19. The apparatus set forth in claim 9, wherein the releasing tool further comprises a knock-out pin provided movably forwardly and rearwardly in a central portion of the core, and connection between the cured resin inside the injection gate opening and the cylindrical molded body is cut by raising the knock-out pin. --.

-- 20. The apparatus set forth in claim 10, wherein the releasing tool further comprises a knock-out pin provided movably forwardly and rearwardly in a central portion of the core, and connection between the cured resin inside the injection gate opening and the cylindrical molded body is cut by raising the knock-out pin. --.